

Work Order ID 132970

Wednesday, May 20, 2015 11:43:23 AM

132970

Page 1

Item ID: D4858-041L02 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Dome Light Housing Assembly, Black
Start Date: 5/20/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/20/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: MAY 20 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4858	A								
100		0.00							DAS 07 9-89
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								15/05/22
110		0.00							DAS 07 9-89
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D4858-041								15/05/20.
	1) Install air vents								
	2) Install lights								
	3) Install rheostats								
	4) Install wiring harness								

P.T.O.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							DEC 10 2015 38 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>Mf008</u> Memo	0.00 0.00							DEC 10 2015 MLJ
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							DEC 10 2015 MLJ

MLJ DEC 10 2015

Picklist Print

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Work Order ID: 132970

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Parent Item: D4858-041L02

D4858-041L02

Parent Item Name: Dome Light Housing Assembly, Black

Start Date: 5/20/2015

Required Date: 5/20/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 13/09/13 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4858-1L02		Manufactured	No			100	Each	7.0000	1	2			DAS 07 9-89
------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	-------------------

D4858-1L02
Dome Light Housing, Black

★★

Location	Loc Qty	Loc Code
MF <u>B119192</u>	7	
118896	3	
125729	4	

2

15/05/26

D4886-1		Manufactured	No			100	Each	2.0000	2	4			DAS 07 9-89
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	-------------------

D4886-1
Air Vent

★★

Location	Loc Qty	Loc Code
ST137 <u>127803</u>	2	
118874	2	

4

15/05/27

D4897-041		Manufactured	No			100	Each	6.0000	1	2			DAS 07 9-89
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	-------------------

D4897-041
Dome Light Wiring

★★

Location	Loc Qty	Loc Code
MF <u>128025</u>	6	
	6	

2

15/05/26

D4898-1		Manufactured	No			100	Each	110.0000	12	24			DAS 07 9-89
---------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	-------------------

D4898-1
Screw, Stainless Steel

★★

Location	Loc Qty	Loc Code
MF	10	
107709	10	
ST137	100	
<u>127703</u>	100	

24

15/05/26

Picklist Print

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132970

Parent Item: D4858-041L02

D4858-041L02

Parent Item Name: Dome Light Housing Assembly, Black

Start Date: 5/20/2015

Required Date: 5/20/2015

Start Qty: 2.00

Required Qty: 2.00

D4906-1 Manufactured No

100

Each

17.0000

1

2

D4906-1

Knob

DAS
07
9-89

15/05/26

Location

Loc Qty

Loc Code

MF

17

107708

7 ✓

128364

10

2

MS21042L06

Purchased

No

100

Each

286.0000

12

24

MS21042L06

Nut

DAS
07
9-89

15/05/26

Location

Loc Qty

Loc Code

ST304

1

m131294

1

ST305

285

m129499

3

m131317

282

24

NAS1149F0663P

Purchased

No

100

Each

127.0000

3

NAS1149F0663P

WASHER

DAS
07
9-89

15/05/26

Location

Loc Qty

Loc Code

st268

127

M128591

2

M131317

125

6

NAS1149FN632P

Purchased

No

100

Each

227.0000

12

NAS1149FN632P

Washer

DAS
07
9-89

15/05/26

Location

Loc Qty

Loc Code

st268

227

m129163

227

24

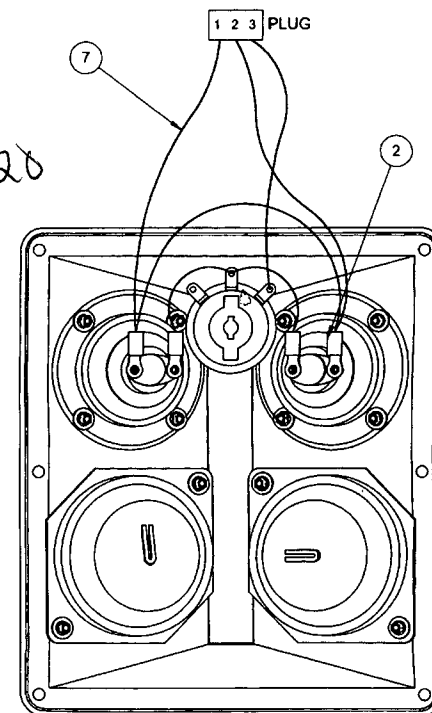
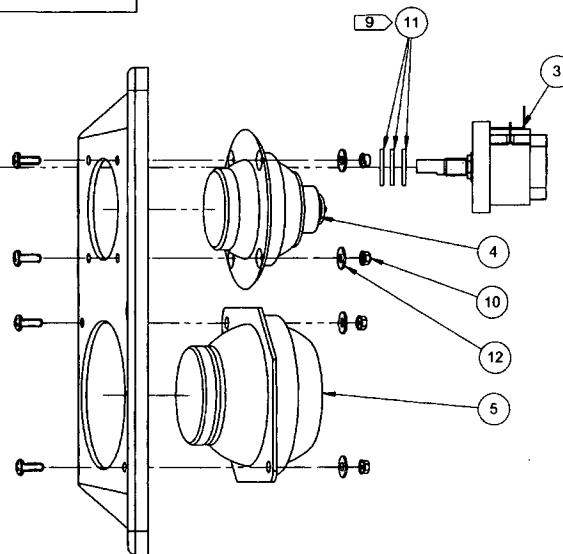
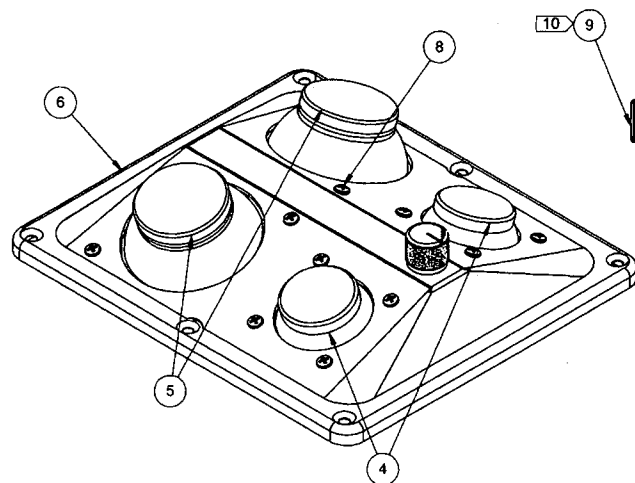
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Shop Packet Print

Page 2

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4858-041	DOMELIGHT HOUSING ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-041)
3	1	D4864-1 (REF)	RHEOSTAT (PART OF D4897-041)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-041)
5	2	D4886-1	AIR VENT
6	1	D4858-1	DOMELIGHT HOUSING
7	1	D4897-041	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	1	D4906-1	KNOB
10	12	MS21042L06	NUT
11	3	NAS1149F0863P	WASHER
12	12	NAS1149FN632P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
VENDOR NOTICE
WORK ORDER
NO. 132930.MJS
15-05-20



D4858-041 DOME LIGHT AIR VENT ASSEMBLY

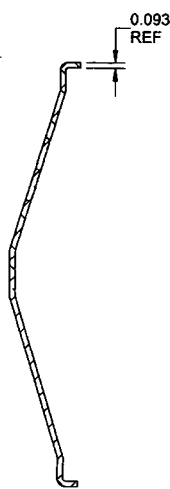
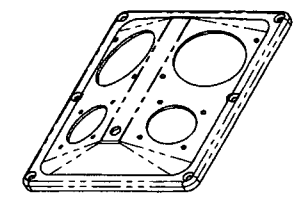
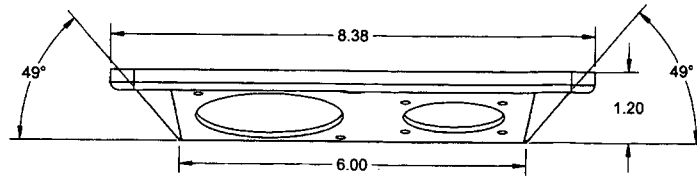
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) REPLACES GENEVA P/N G12983 P112-X
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

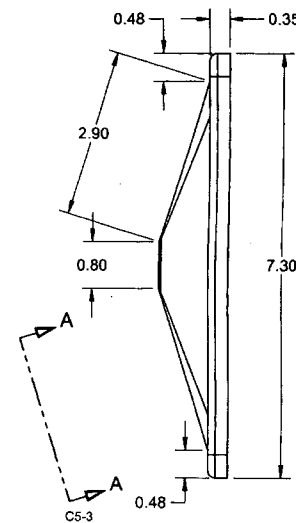
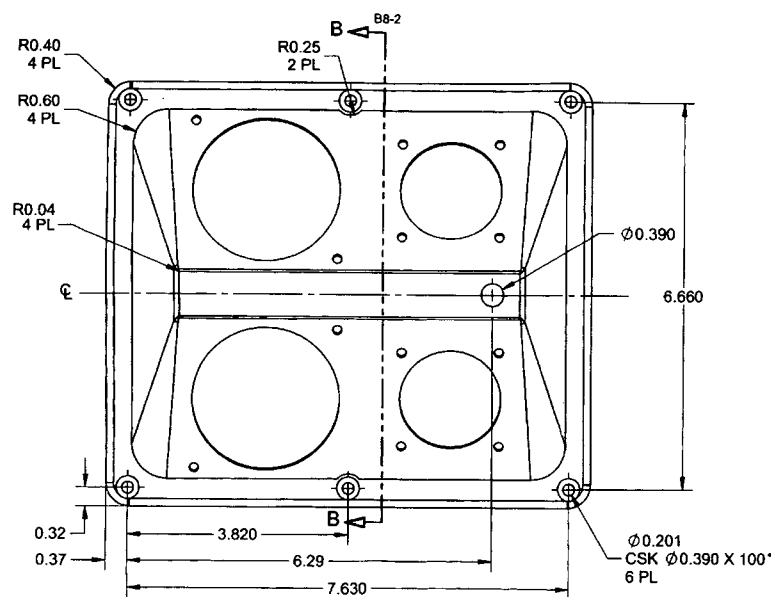
RELEASED
2013-09-16

A	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN	03	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4858 TITLE DOMELIGHT AIR VENT ASSY SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS ISSUED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		
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CHECKED	02			
MFG. APPR.	04			
APPROVED	05			
DE APPR.	06			
DATE	13.07.24			

8 7 6 5 4 3 2 1



SECTION B-B
B5-2



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2013-09-16

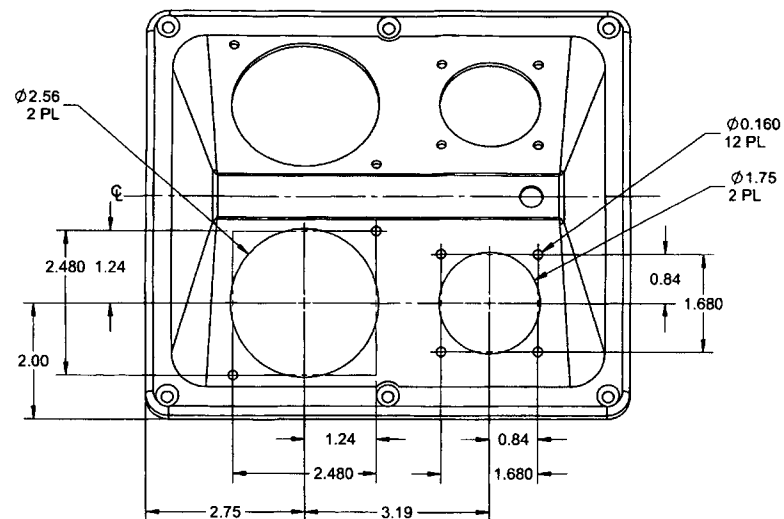
- NOTES:**
 1) MATERIAL: SEE TABLE
 2) TOOLING: THERMOFORM PER MOLD DT9933 PER QSI 022 TRIM PER DT9933
 3) FINISH: N/A
 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 7) IDENTIFICATION: N/A
 8) WEIGHT: 0.22 lbs
 9) REPACES GENEVA P/N G12985
 10) PART SHAPE AND GEOMETRY IS CONTROLLED BY TOOLING
 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

D4858-1 DOME LIGHT HOUSING

PART NUMBER	DESCRIPTION
D4858-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4858-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

DESIGN	03	DART AEROSPACE USA, INC. KENT, WA	
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CHECKED	02	DRAWING NO.	REV. A
MFG. APPR.	04	D4858	SHEET 2 OF 3
APPROVED	05	TITLE	SCALE
DE APPR.	06	DOME LIGHT AIR VENT ASSY	NTS
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8 7 6 5 4 3 2 1



VIEW A-A
B3-2

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DESIGN	OS	DART AEROSPACE USA, INC. KENT, WA	
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MFG. APPR.	HL	D4858	SHEET 3 OF 3
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DE APPR.	HL	DOME LIGHT AIR VENT ASSY	NTS
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DQA:

Date:

16/01/15



QA Closed:

Date:

15/12/14

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>132970</u> Part No. <u>D4858-041402</u> NCR No. <u>15-5500</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date :		Step #: <u>110</u>		QTY Effective : <u>2</u>		MRB (QSI042) Approval <u>PD</u> DEC 08 2015	
Description Work Order Deviation				Disposition		Completed By <u>DR</u> 15/11/18.	
After assembly it was found that D4897-041 wiring harness did not conform to dwg. (ref. NCR. 15-5034)				Sever winding at off position & move wire to un-severed pole. OK as is		Lead hand / Supervisor Approval Verification <u>W</u> 15/11/18. DEC 08 2015	
						QC / QA Coordinator Approval <u>PD</u> DEC 08 2015	
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☒ Heat Treat ☐ Cut Too Short ☐ Mis-labeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐			
OTHER :							